



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3560-2

Job Sheet 190388



Part No: D3560-2

Job Qty: 2 pcs *4 pcs*

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 2/12/19 *Feb 19*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 06-11-10 JLM use -042 IPP REV:B 13.06.03 PER DWG REV.F DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs	2/12/19	2/12/19	0.00	0.14	Bandsaw - 1	<i>DAS</i>	<i>19/02/16</i>
110	HAAS 4 Axis - B4B	2 pcs	2/12/19	2/12/19	0.38	1.32	HAAS - 1 - B4B	<i>52</i>	<i>17/02/17</i>
							HAAS - 2 - B4B	<i>9-89</i>	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	2 pcs	2/12/19	2/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	<i>DAS</i>	
							QC 2 - 52	<i>52</i>	<i>19/02/17</i>
							QC 2 - 54	<i>9-89</i>	
							QC 2 - 56		



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Container No: S154650



Part: D3560-2

Job No: 190388

Serial No/Batch: S154650

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/19/19

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					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
125	Conventional Mill - 1 - B4B	2 pcs	2/12/19	0.00 0.07	Conventional Mill - 1 - B4B	19/02/19
					Conventional Mill - 2 - B4B	
130	QC 8	2 pcs	2/12/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	A-019-02-19
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
210	Packaging 3-1 - Stock - B4B	2 pcs	2/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	SL4
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
220 QC 21 - SA	2 pcs	2/12/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Cut blanks 16.750" long
 Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA694 Rev: D & Dwg D3560 Rev: D
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 125 - (Manufacture as per dwg)
 130 - (QC8- Inspect parts - second check)
 210 - (Identify as per dwg & Stock Location: _____), LOCATION: WA003
 220 - (QC21- Final Inspection - Work Order Release)

DAS 21 FEB 19 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	2.7900 ft (1.395 ea)	100-Bandsaw - 1	5036667

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X05.000	3	16	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	0.507Inches + 0.000 - 0.001	0.507 0.506	Diameter	0.506
2	Arm	0.196Inches + 0.005 - 0.001	0.201 0.195	Diameter	0.195
3	Arm	1.000Inches + 0.010 - 0.001	1.010 0.999	Diameter	1.000
4	Arm	0.500Inches ± 0.010	0.510 0.490		0.500
5	Arm	0.250Inches ± 0.010	0.260 0.240		0.250
6	Arm	0.275Inches ± 0.010	0.285 0.265		0.275
7	Arm	0.188Inches ± 0.010	0.198 0.178		0.188
8	Arm	2.000Inches ± 0.010	2.010 1.990		2.000
9	Arm	1.700Inches ± 0.010	1.710 1.690		1.700
10	Arm	0.385Inches ± 0.010	0.395 0.375	Diameter	0.385"
11	Arm	100.000Degrees ± 0.500	100.500 99.500	Angle	100°
12	Arm	0.250Inches ± 0.010	0.260 0.240	Depth	0.250

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DAS 52 19/02/17
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					